

Date: Monday, 6/5/2006 7:41:08 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : DOOR  
 Job Number : 27343  
 Estimate Number : 12267  
 P.O. Number : N/A Part Number : D3140104  
 This Issue : 6/5/2006 S.O. No. : N/A Drawing Number : D3140 REV D1  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : D1  
 Previous Run : 25739 Material : N/A  
 Written By : *SKG Comment Below* Due Date : 6/30/2006 Qty: 4 Um: Each  
 Checked & Approved By : *06.06.05*  
 Comment : Est Rev:A New Issue 06-02-08 JLM  
 Est. Rev B New dwg rev. ecn781 06.04.18 EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S032 2024-T3-.032 sheet



Comment: Qty.: 0.0578 sf(s)/Unit Total: 0.2310 sf(s)  
 2024-T3 .032 " Thick sheet  
 (M2024T3S032)  
 Batch: *M12758 / M10147* → *FF 06-06-21* *34*

2.0 SHEAR SHEAR



Comment: SHEAR  
 Cut Blanks 2.88" x 2.88 as per Dwg D3140 *FF 06-06-14* *4*

3.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
 1-Deburr  
 2-Cut Angle as per Dwg D3140 *FF 06.06.14* *4*

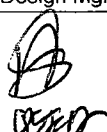
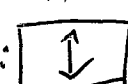
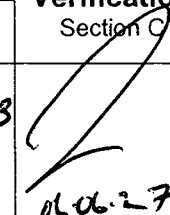
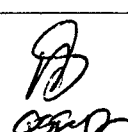
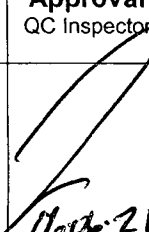
4.0 BRAKE NC NC BRAKE




Comment: NC BRAKE


Form as per Dwg D3140 *06/06/2004*  
*SP 06/06/19 4*  
*(PTO)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR: 27343		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06-06-21	2	grain in wrong direction.		Scrap - replace parts. Place grain direction on the part itself on the dwg. ex: 	FF 06-06-23	 06-06-27		 06-06-21

Part No: D340-104 PAR #: N/A Fault Category: Proc / FAB. AS <sup>media small</sup> NCR: Yes No DQA:  Date: 06/06/29

NOTE: Date & initial all entries

QA: N/C Closed:  Date: 06.06.29

Date: Monday, 6/5/2006 7:41:08 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR

Job Number: 27343

Part Number: D3140104

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



*06-06-26 (4)*



*06-06-27 (4)*

Comment: INSPECT WORK TO CURRENT STEP

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*06-06-28*

*(4)*

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*06-06-28 (4)*

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *57409*

*06-06-28 (4)*

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*06-06-29*  
*06-06-28*

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



DESIGN DS	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3140	REV. D SHEET 1 OF 7
DATE 05.11.23		TITLE DOOR	SCALE NTS
A	02.04.18	NEW ISSUE	
B	03.01.23	REMOVE -65/-81/-83; ADD -301/-303	
C	04.11.08	CHANGE DELASTEK SPEC. TEC-77; ADD PART MARKING; ADD NOTES 11, 12, 13; CHANGE ANGLE -95/-97/-98 TO 106°	
D	05.11.23	ADD -103/-104/-105/-106; REMOVE -67	
DI	<del>06.03.31</del>	1.75 WAS 1.88; 4.75 WAS 4.13	

RELEASED  
05.12.01 *[Signature]*

QTY -05	QTY -06	QTY -07	QTY -08	QTY -09	QTY -10	PART NUMBER	DESCRIPTION
X						D3140-05	DOOR
	X					D3140-06	DOOR
		X				D3140-07	DOOR
			X			D3140-08	DOOR
		1		X		D3140-09	DOUBLER ASSEMBLY
			1		X	D3140-10	DOUBLER ASSEMBLY
3	3					D3140-57	PAD
1	1					D3140-59	PAD
2	2					D3140-61	PAD
2	2					D3140-63	PAD
		1	1			D3140-69	PAD
		1	1			D3140-71	PAD
		1	1			D3140-73	PAD
		1	1			D3140-75	PAD
		1	1			D3140-77	PAD
		1	1			D3140-79	PAD
				1	1	D3140-85	ANGLE
1	1					D3140-87	DOUBLER
				1	1	D3140-89	DOUBLER
		1				D3140-91	DOUBLER
			1			D3140-92	DOUBLER
3	3					D3140-95	DOUBLER
1						D3140-97	DOUBLER
	1					D3140-98	DOUBLER
		1	1			D3140-99	DOUBLER
		2	2			D3140-101	DOUBLER
		1				D3140-103	DOUBLER
			1			D3140-104	DOUBLER
		1				D3140-105	DOUBLER
			1			D3140-106	DOUBLER
1	1					D3140-241	DOUBLER
1		1				D3140-301	DOUBLER
	1		1			D3140-303	DOUBLER
				5	5	MS20426AD3-4	RIVET

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 27343

Copyright © 2002 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

**DART**

DESIGN DS	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3140	REV. D SHEET 2 OF 7
DATE 05.11.23		TITLE DOOR	SCALE NTS

1

COMPOSITE LAYUP & BONDING I.A.W. DELASTEK PROCESS SPEC. TEC-77  
MATERIAL STORAGE & HANDLING TO BE I.A.W. DART QSI 006  
MAIN LAYUP USES FIBERCOTE E-761/7781 EPOXY FIBERGLASS.  
FILL WITH EPOCAST 87269 OR MAGNOBOND 77 A & B AND MA560 FOAM/ NB-51/30 FOAM

2

FINISH: DUPONT HIGHBUILD GREY PRIMER 1144-S

3

MAKE PARTS IN ACCORDANCE WITH THE FOLLOWING TOOLS/MOLDS:

PART	TOOL
D3140-05	B30-23000-01T
D3140-06	B30-23000-02T
D3140-07	B30-23000-03T
D3140-08	B30-23000-04T
D3140-57	B30-23000-57T
D3140-61	B30-23000-61T
D3140-63	B30-23000-63T
D3140-69	B30-23000-69T
D3140-71	B30-23000-71T
D3140-73	B30-23000-73T
D3140-75	B30-23000-75T
D3140-77	B30-23000-77T
D3140-79	B30-23000-79T
D3140-89	D3140-89T1
D3140-301	D3140-301T1
D3140-303	D3140-303T1

**RELEASED**  
05.12.01

4

MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

5

MATERIAL: 2024-T3 (QQ-A-250/4) 0.020 THICK (M2024T3S.020)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

6

MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.040 THICK (M5052H32S.040)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

7

MATERIAL: POLIMEX TR75 1" THICK 4.5 LB KLEGECELL

8

ALL DIMENSIONS IN INCHES

9

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

10

MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (M6061-T6S.063)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

11

DOUBLER TO SIT ON TOP OF FOAM AT THIS LOCATION

12

DOUBLER TO BE RECESSED FLUSH INTO FOAM AT THIS LOCATION

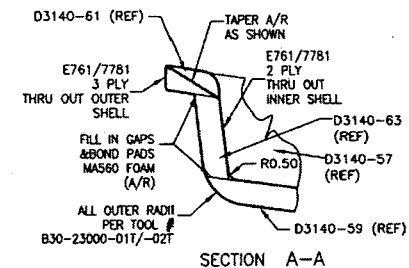
13

RUBBER STAMP WITH DART P/N D3140-05/-06/-07/-08 USING MIL-STD-130

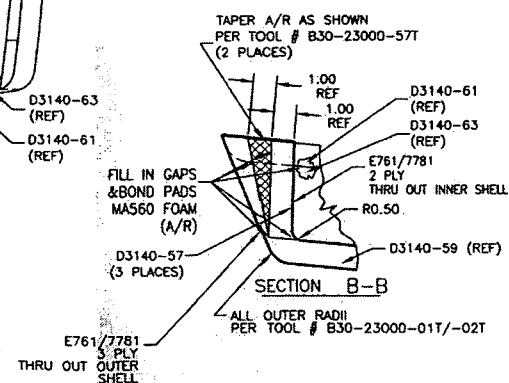
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 27343

Copyright © 2002 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



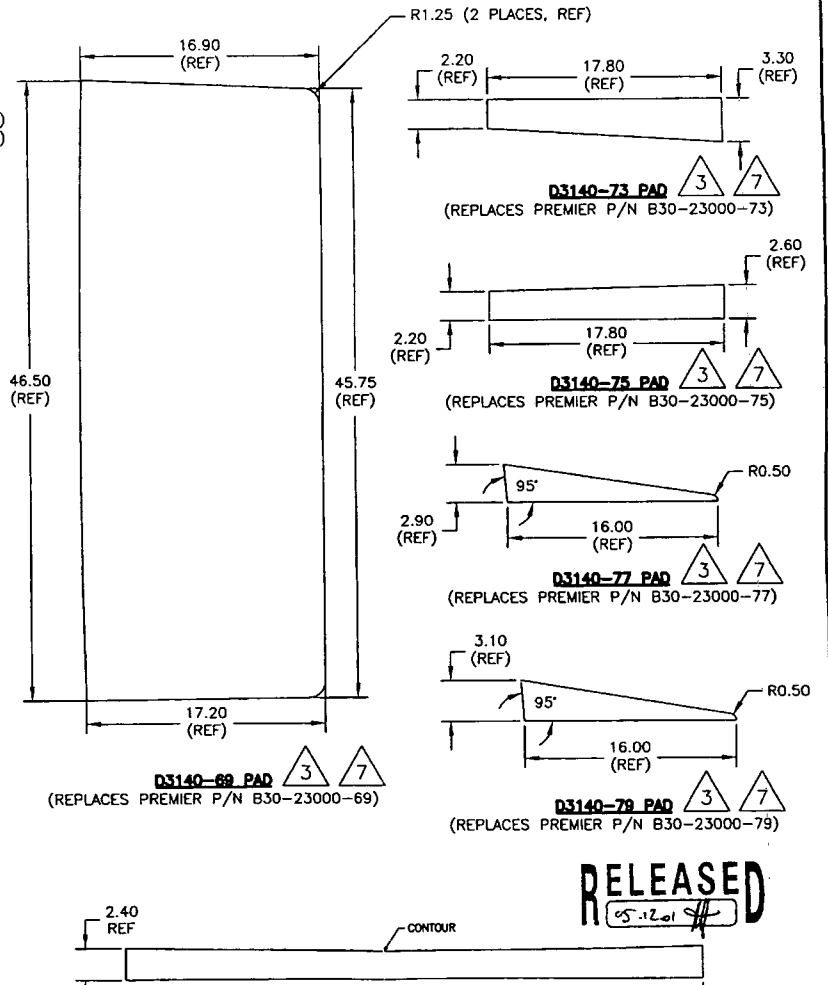
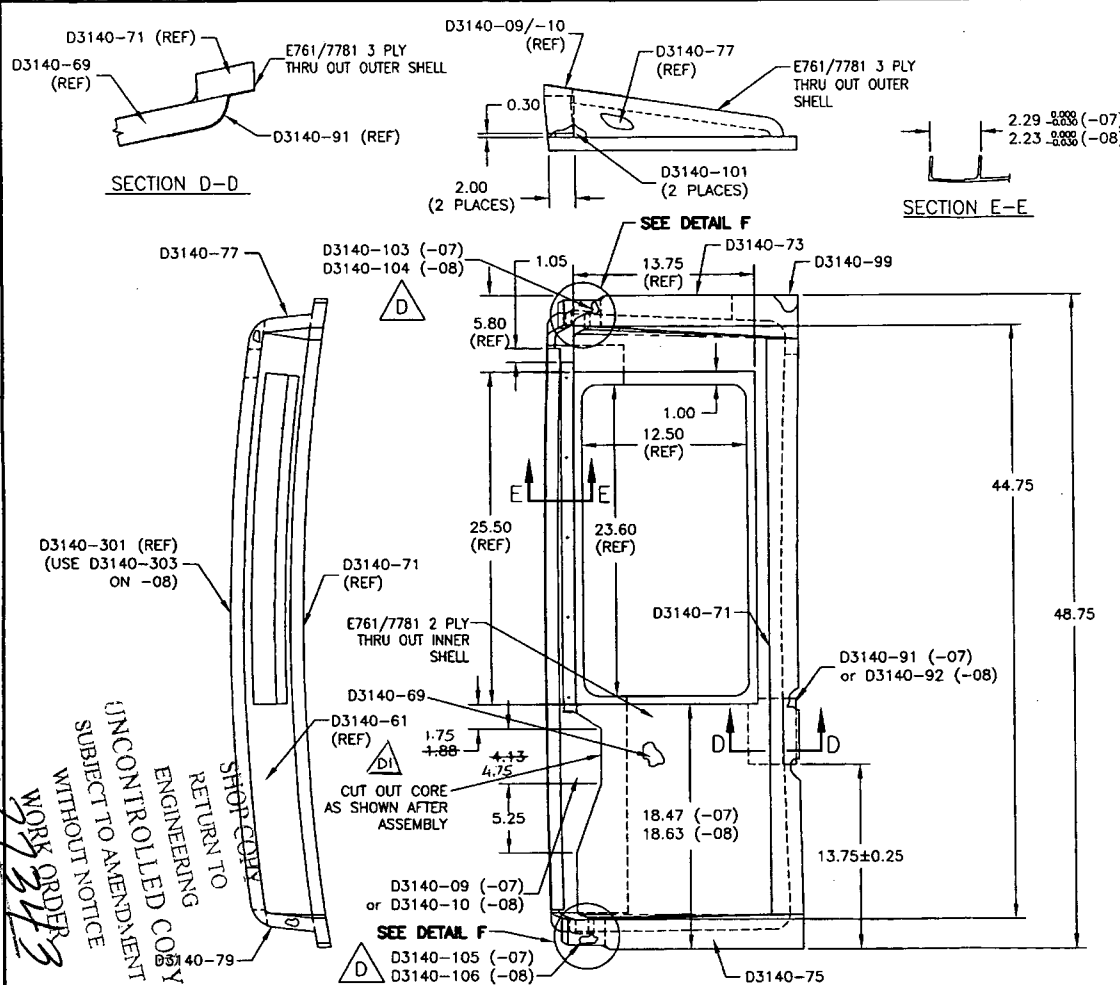
RELEASED  
05.12.01



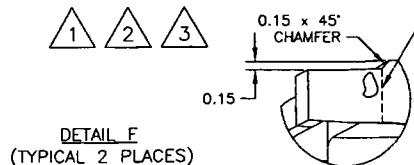
Three triangles are shown, labeled 1, 2, and 3 from left to right. Each triangle is an isosceles triangle with its base at the bottom. The numbers 1, 2, and 3 are placed inside each triangle, centered below the base.

DESIGN DS	DRAWN BY RF	<b>DART</b>	DART AEROSPACE LTD. HARRISBURY, ONTARIO, CANADA
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3140	REV. SHEET 3 OF 3
DATE 05.11.23	TITLE DOOR		SCALE NTP

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 27343



**D3140-07 DOOR (SHOWN, REPLACES PREMIER P/N B30-23000-07)**  
**D3140-08 (OPPOSITE, REPLACES PREMIER P/N B30-23000-08)**  
(WINDOW TO BE LOCATED BY TOOL B30-23000-03T/-04T)

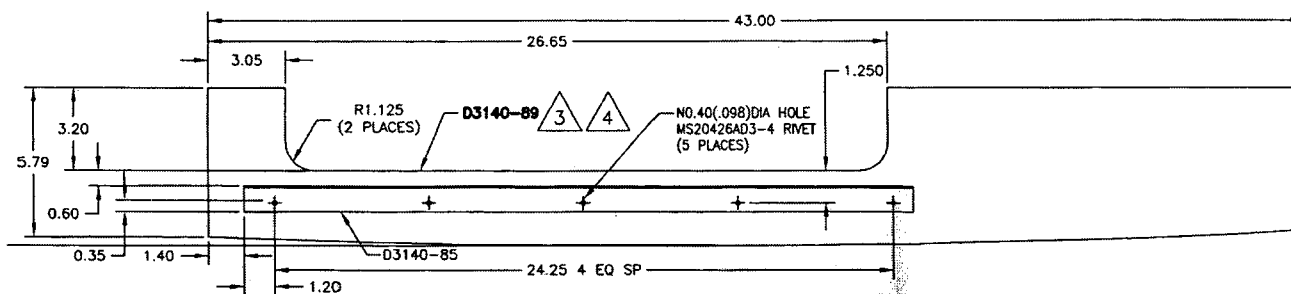


DESIGN DS		DRAWN BY RF		DART DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3140		REV. D	
DATE 05.11.23		TITLE DOOR		SHEET 4 OF 7	
				SCALE NTS	

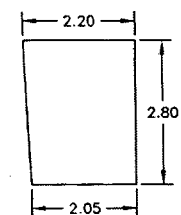
NO. 27343  
WORK ORDER  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

RELEASED

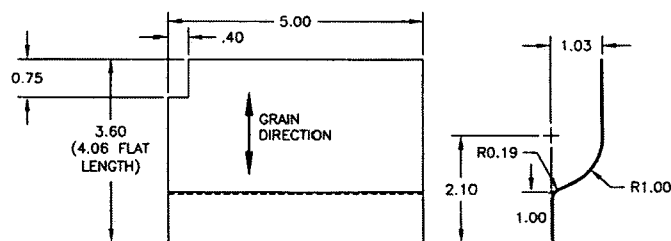




**D3140-10 DOUBLER ASSEMBLY (SHOWN, REPLACES PREMIER P/N B30-23000-10)**  
**D3140-09 DOUBLER ASSEMBLY (OPPOSITE, REPLACES PREMIER P/N B30-23000-09)**

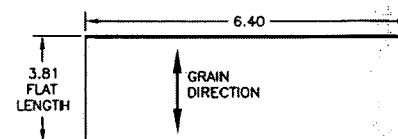


**D3140-101 DOUBLER** (4)  
 (REPLACES PREMIER P/N B30-23000-101)

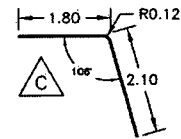


**D3140-91F FLAT PATTERN**  
 (USE TO MAKE D3140-91/-92 DOUBLERS)

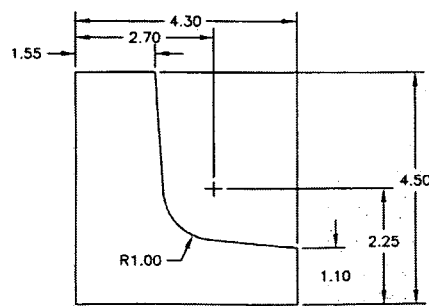
**D3140-91 DOUBLER** (4)  
 (SHOWN, REPLACES PREMIER P/N B30-23000-91)  
**D3140-92 DOUBLER**  
 (OPPOSITE, REPLACES PREMIER P/N B30-23000-92)



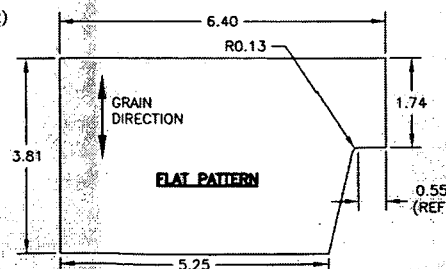
**D3140-95 DOUBLER** (4)  
 (REPLACES PREMIER P/N B30-23000-95)



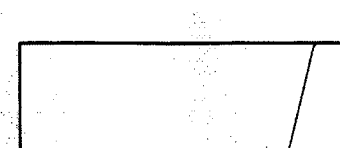
**RELEASED**



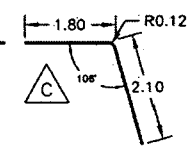
**D3140-98 DOUBLER** (4)  
 (REPLACES PREMIER P/N B30-23000-99)



**D3140-97F FLAT PATTERN**  
 (USE TO MAKE D3140-97/-98 DOUBLERS)



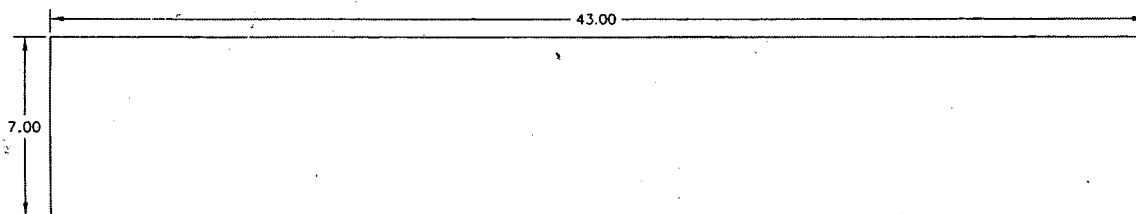
**D3140-97 DOUBLER** (4)  
 (SHOWN, REPLACES PREMIER P/N B30-23000-97)  
**D3140-98 DOUBLER**  
 (OPPOSITE, REPLACES PREMIER P/N B30-23000-98)



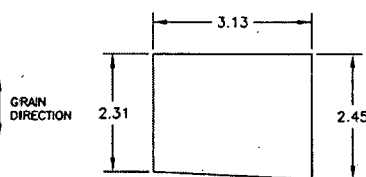
**BEND DETAIL**

COPYRIGHT © 2002 BY DART AEROSPACE LTD.		DESIGN DS	DRAWN BY RF	<b>DART</b>	DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED	APPROVED	DRAWING NO. D3140	REV. 0
DATE 05.11.23		TITLE DOOR		SHEET 5 OF 7	
				SCALE NTS	

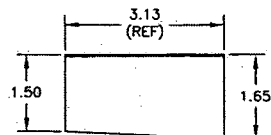
NO  
 WORK ORDER  
 27343  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 UNCONTROLLED COPY  
 RETURN TO  
 SHIP COPY  
 ENGINEERING



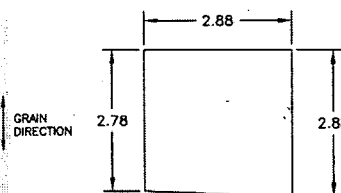
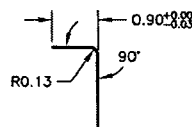
**D3140-87 DOUBLER**  $\triangle 4$   
(REPLACES PREMIER P/N B30-23000-87)



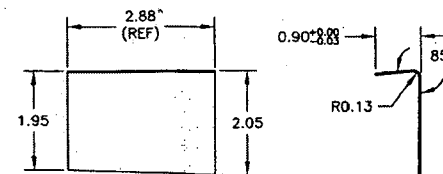
**D3140-105F FLAT PATTERN**  
(USED TO MAKE D3140-105/-108 BRACKETS)



**D3140-105 DOUBLER**  $\triangle 4$   $\triangle D$   
**D3140-106 OPPOSITE**

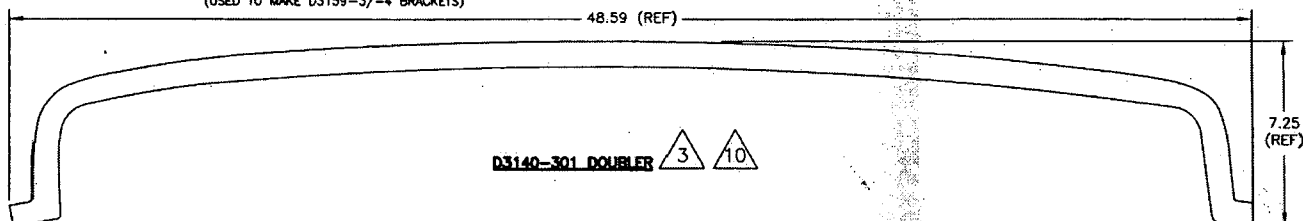


**D3140-103F FLAT PATTERN**  
(USED TO MAKE D3140-103/-104 BRACKETS)

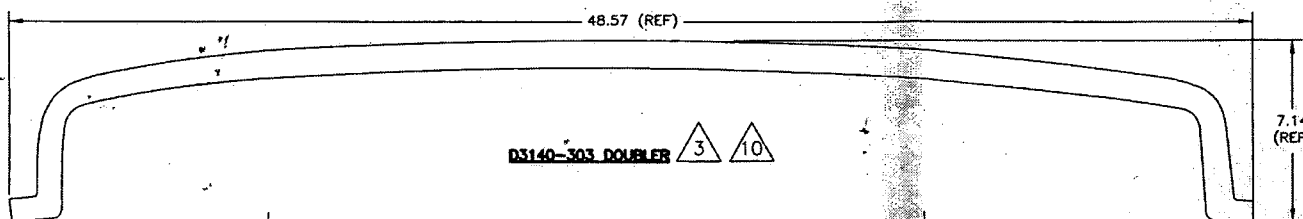


**D3140-103 DOUBLER**  $\triangle 4$   $\triangle D$   
**D3140-104 OPPOSITE**

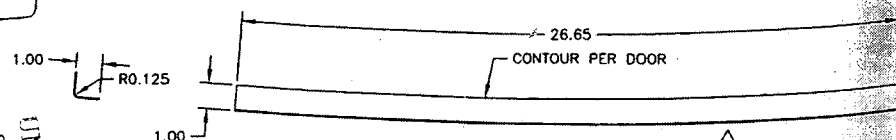
**D3159-3F FLAT PATTERN**  
(USED TO MAKE D3159-3/-4 BRACKETS)



**D3140-301 DOUBLER**  $\triangle 3$   $\triangle 10$



**D3140-303 DOUBLER**  $\triangle 3$   $\triangle 10$



**D3140-85 ANGLE**  $\triangle 6$   
FLAT PATTERN: 26.65" x 1.90"  
(REPLACES PREMIER P/N B30-23000-85)

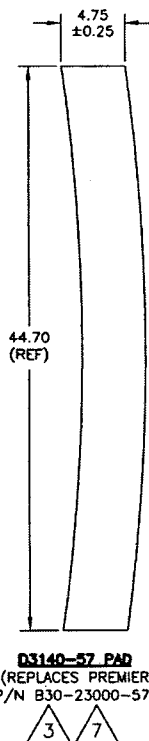
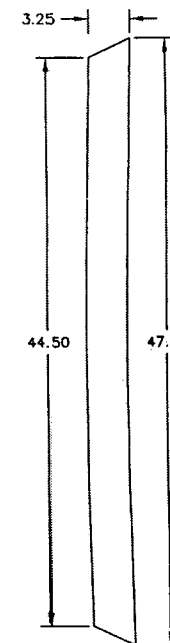
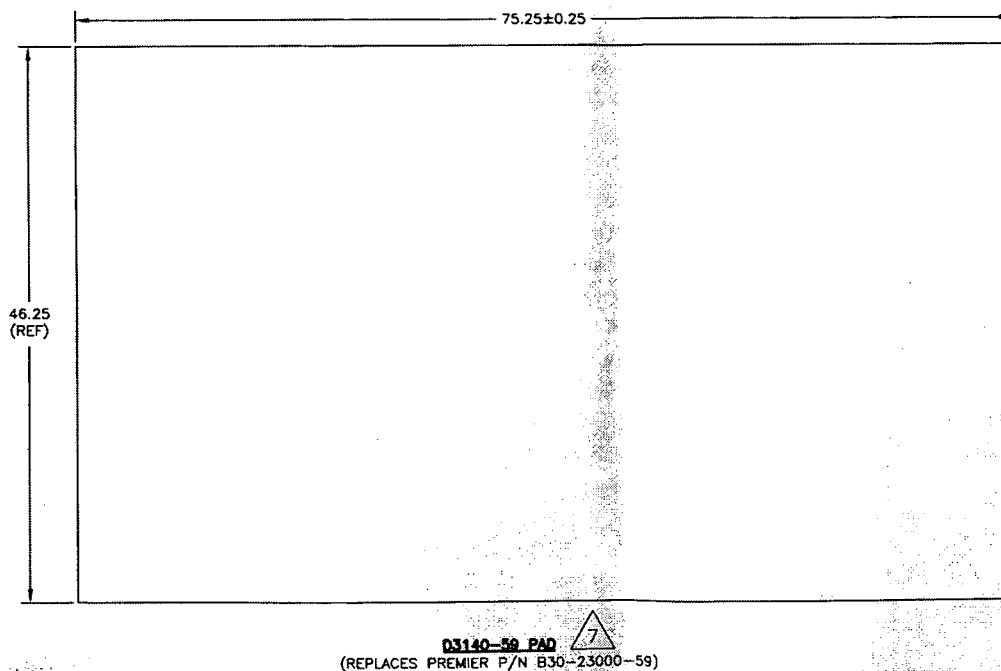
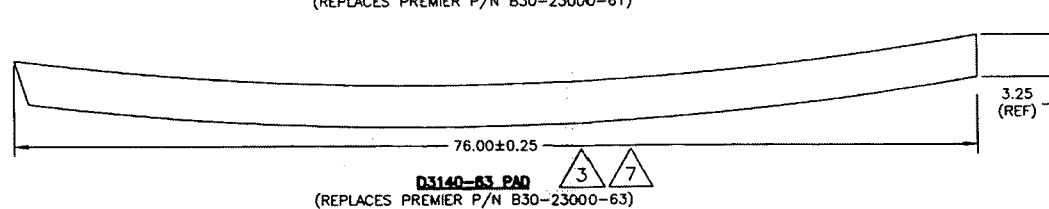
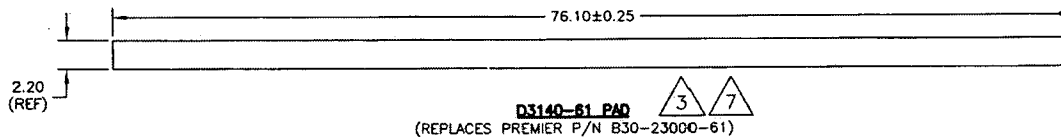
RELEASED  
05.12.01

COPYRIGHT © 2002 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DESIGN DS	DRAWN BY RF	<b>DART</b>	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED #	APPROVED #	DRAWING NO. D3140	REV. D SHEET 6 OF 7
DATE 05.11.23		TITLE DOOR	SCALE NTS

NO. 27343  
WORK ORDER  
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE



RELEASED

R1.00  
(2 PLACES, REF)

COPYRIGHT © 2002 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DESIGN DS	DRAWN BY RF	<b>DART</b>	DART AEROSPACE LTD. WARRICKBURT, ONTARIO, CANADA
CHECKED H	APPROVED H	DRAWING NO. D3140	REV. 0 SHEET 7 OF 7
DATE 05.11.23	TITLE DOOR	SCALE NTS	

WORK ORDER  
273473  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
ENGINEERING  
RETURN TO  
SHOP COPY